

Work Order ID 50966



Page 1

July 28, 2009 11:43:41 AM

Item ID: D3011-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Rappel

Start Date: 31/07/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 04/08/2009 Req'd Qty: 10.00



Customer:

Reference: J/A 09-07-28

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3011	Rev B

100

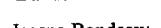


BAND SAW

0.00

10 0

Bandsaw



Memo

0.00

J.A 09/07/28



Jeaspa Bandsaw

Cut Blanks: 26.625"

110



HAAS CNC VERTICAL MACHINING #1

0.00

10 2

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

BB 09/07/30 / J.A 09/08/01



Machine as per folio FA129

Folio Rev: B

Dwg Rev: B

W/O#:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3011-1 PAR #: Fault Category: Prod eng according to NCR: Yes No DQA: Date: 05-05-09
 Scrapp / scrapp. QA: N/C Closed: Date: 05-05-09

NCR: 50966		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/07/30	110	One part have rougher mark on it. R.C. during machining the part lift from the vise causing by new routine on rougher tool feed too fast. Program fixed. All process / program over.	051042	- Replace B to <u>50360</u> - Scrupp & destroy. See below ↓	88 09/07/30	J.F. 04/08/04	051042	0507-30
		One part the dimension of 1.250" +.030 was too small 1.233. R.C. programming error.	051042	- Scrupp & destroy. & replace. update the program. & attach revision.	0 09/07/30	0 04/08/04	051042	0507-30
(A)								
(B)								

NOTE: Date & initial all entries

KC 1960

1960

1960. 1960 No. 1960
or how do you know?

well where does?

the water left today
and now we will
have to go to the
water again.

where does?

1960 no good place where

where to go to

Work Order ID 50966



Page 2

July 28, 2009 11:43:41 AM

Item ID: D3011-1

Accept



Setup Start



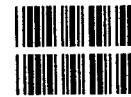
Revision ID: B

Stop



Item Name: Rappel

Start Date: 31/07/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 04/08/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

H.A 09/08/01

10

0

130

QC8- Inspect parts - second check

0.00



QC

Quality Control

Memo

0.00

and 09/08/02

10

0

131



Outsource2

Memo P10: 10/69

0.00

0.00

Outsource process - NDT

LPI AS PER ASTM 1417 LEVEL 2 AS PER DWG d3011

CD 09/08/05 10

rec'd + inspect + attal report

CD 09/08/05

Work Order ID 50966



Page 3

July 28, 2009 11:43:41 AM

Item ID: D3011-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Rappel

Start Date: 31/07/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 04/08/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

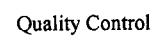
132



QC5- Inspect part completeness to step on W/O

0.00

QC



Memo

0.00

Quality Control

140



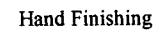
Chemical Conversion Coat per QSI005 4.1

0.00

09-08-05

JB

HandFinish



Memo

0.00

Hand Finishing

150



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat



Memo

0.00

Powder Coating

START TIME: 11:40AM
OVEN TEMPERATURE: 320°
FINISH TIME: 12:10PM

M112148

09-08-05

X(10)

W

Work Order ID 50966

Page 4

July 28, 2009 11:43:41 AM

Item ID: D3011-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Rappel

Start Date: 31/07/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 04/08/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

160



QC3- Inspect Part Finish

0.00

BL 09-08-5.

(D)

QC

Quality Control

0.00

170



Identify as per dwg & Stock Location: 6-A

0.00

Packaging

Packaging

Memo

0.00

180



QC21- Final Inspection - Work Order Release

0.00

09/08/25 HJ

QC

Quality Control

Memo

0.00

Picklist Print

Page 1

July 28, 2009 11:43:41 AM

Work Order ID: 50966



Parent Item: D3011-1RevB



Parent Item Name: Rappel

Start Date: 31/07/2009

Required Date: 04/08/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6202RevA		Manufactured	No			110	f	14.0000	10.0000			

I-Beam Extrusion



Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

14

B.A 09/07/28

50040

50630

14

125

22.6666

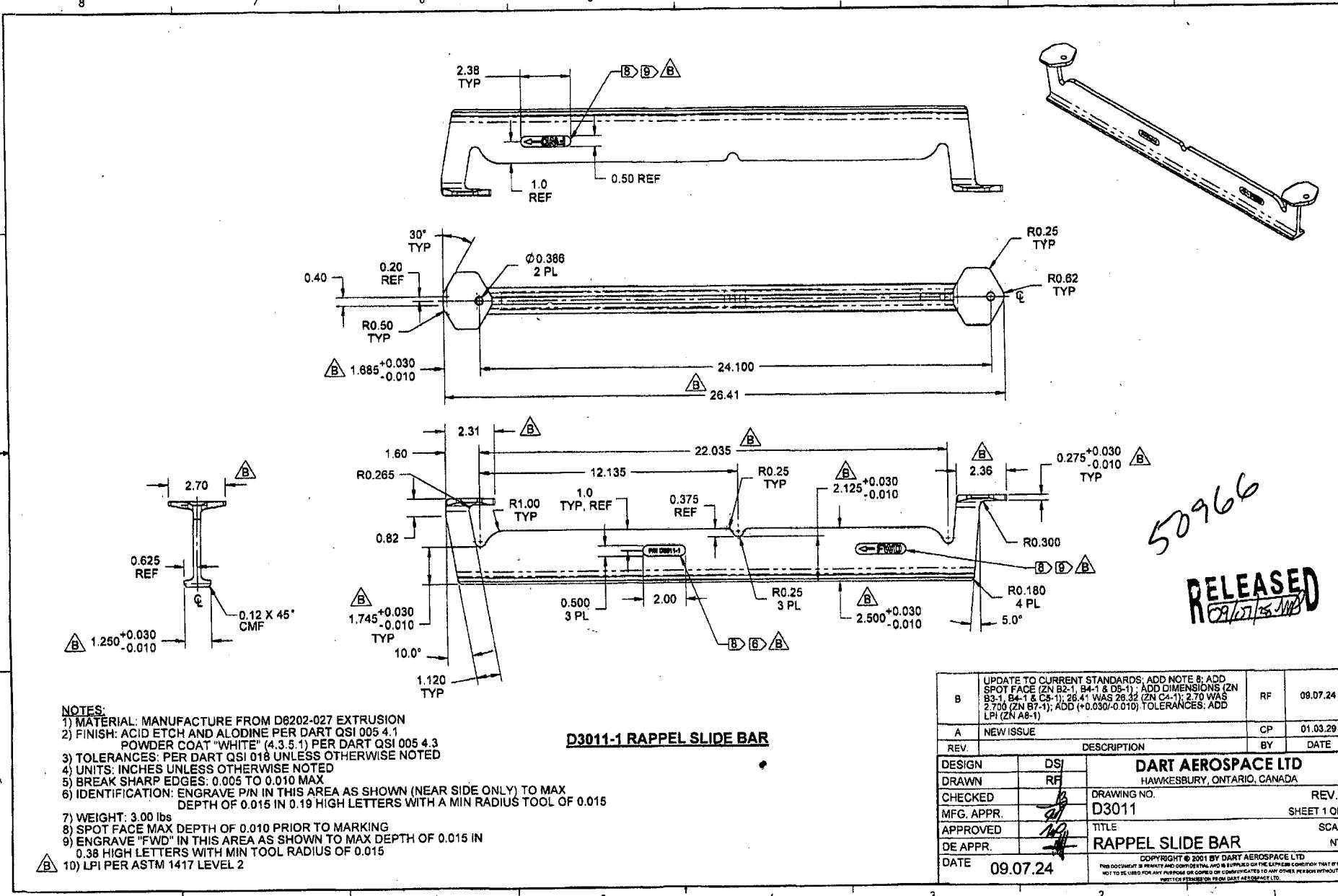
DART AEROSPACE LTD	Work Order:	SO966
Description:	Part Number:	3011-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>SB</i>	Audited by:	<i>mf</i>	Prototype Approval:	N/A
Date:	09/02/30	Date:	09/08/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





LIQUID PENETRANT TEST REPORT

P- 14944.

CLIENT	DART AEROSPACE			DATE	Aug 4-2009		
ATTENTION	LINDA / CHANTEL			ACUREN JOB NO.	108-09-001480		
ADDRESS	1270 ABERDEEN ST HAWKESBURY ON.			PO/WO NO.	10169		
PROJECT	KGH 1K7			WORK LOCATION	HAWKESBURY		
ITEM(S) EXAMINED	F.P.I. ON MACHINED PARTS AND CROSS TUBES.			ACCEPTANCE STD.	ASTM 1417 REV./DATE 2007		

JOB DESCRIPTION	PROCEDURE NO.	LT-0002	REV./DATE	TECHNIQUE NO.	LT- 0002	REV./DATE
PART NO.				MATERIAL	S.S. / ALUMINUM	THICKNESS
SCOPE	WET FLUORESCENT LIQUID PENETRANT INSPECTION CARRIED OUT 100% EXTERNAL.					

TEST DETAILS							
METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED		
FAMILY BRAND	MAGNAFLUX		BLACK LIGHT S/N 16459			<input type="checkbox"/> OUTPUT > 1000 μW/cm²	<input type="checkbox"/> AMBIENT < 2 fc
PENETRANT	ZL 67	MINIMUM DWELL TIME	45 10 MIN.	LIGHTING EQUIP.			<input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER	H ₂ O	MINIMUM DRY TIME	>10 MIN.	OTHER LABINO			<input type="checkbox"/> CAL DUE DATE
DEVELOPER	SKO 52	MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N			DEC. 8 - 2009.
DEVELOPER TYPE	<input type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY				

TEST SURFACE							
SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input checked="" type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL		
SURFACE TEMPERATURE	< - 4°C/ 20°F			- 4°C/ 20°F TO 10°C/50°F			<input type="checkbox"/> 10°C/50°F TO 52°C/125°F <input type="checkbox"/> > 52°C/125°F

RESULTS- (<input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL)							
ITEM	DESCRIPTION	ACCEPT	REJECT				
W.O. 50388	40 MACHINED PARTS	✓		<p>All Items Inspected Were Found Acceptable</p> <p>MM 09 08 05</p>			
W.O. 50965	10 PCS						
W.O. 50966	10 PCS	✓					
W.O. - 50796	- 1 PC	✓					
W.O. - 50798	- 1 PC	✓					
W.O. - 50797	- 1 PC	✓					
W.O. - 50667	- 1 PC	✓					

Scope of Services
 The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
 In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES			
CLIENT REPRESENTATIVE	MATTHEW MOROCCO		DTR # E-20066.
TECHNICIAN (SIGNATURE):	N.K. JENSTON		REPORT REVIEWED BY:
NAME (PRINT):			NAME INITIALS
CGSB LEVEL	1 ST TECHNICIAN	2 ND TECHNICIAN	
SNT LEVEL			
CGSB REG. NO.	CGSB REG. NO.		

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY